

Date: Monday, 12/01/2009 3:22:45 PM  
User: Chantal Lavoie

# Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: MOUNTING LUG
<b>Job Number</b>	: 44701		
<b>Estimate Number</b>	: 10256		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D22303
<b>This Issue</b>	: 12/01/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2230 REV F
<b>First Issue</b>	: 11	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 44546	<b>Drawing Revision</b>	: F
		<b>Material</b>	:
<b>Written By</b>	: <u>[Signature]</u>	<b>Due Date</b>	: 27/01/2009
<b>Checked &amp; Approved By</b>	: <u>C209/01/12</u>	<b>Qty:</b>	100
<b>Comment</b>	: Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s)  
Lug Extrusion  
D2423  
Batch: 43722

2.0	D22303P	LUG
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R10: 7950

C209/01/13 (100)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)  
LUG

3.0	BAND SAW	BAND SAW
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Comment: Band Saw  
Cut D2423 extrusion to 0.82"  
Batch: \_\_\_\_\_

Cut @ metric

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Machine per folio D2230-3  
Check for crack while loading into the machine.

need + inspect for trans + damage

C+C attached

5.0	QO2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

R 09/01/28 100  
S 09/01/29 100  
counter

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 3:22:46 PM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 44701

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*n/a*

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

*n/a*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*100*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*09/01/29*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

*M 109996*

START TIME:

*9:00*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*9:30*

*100*

*09-01-30*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

*M-L*

*09/01/30*

*100X*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*09/2/4*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

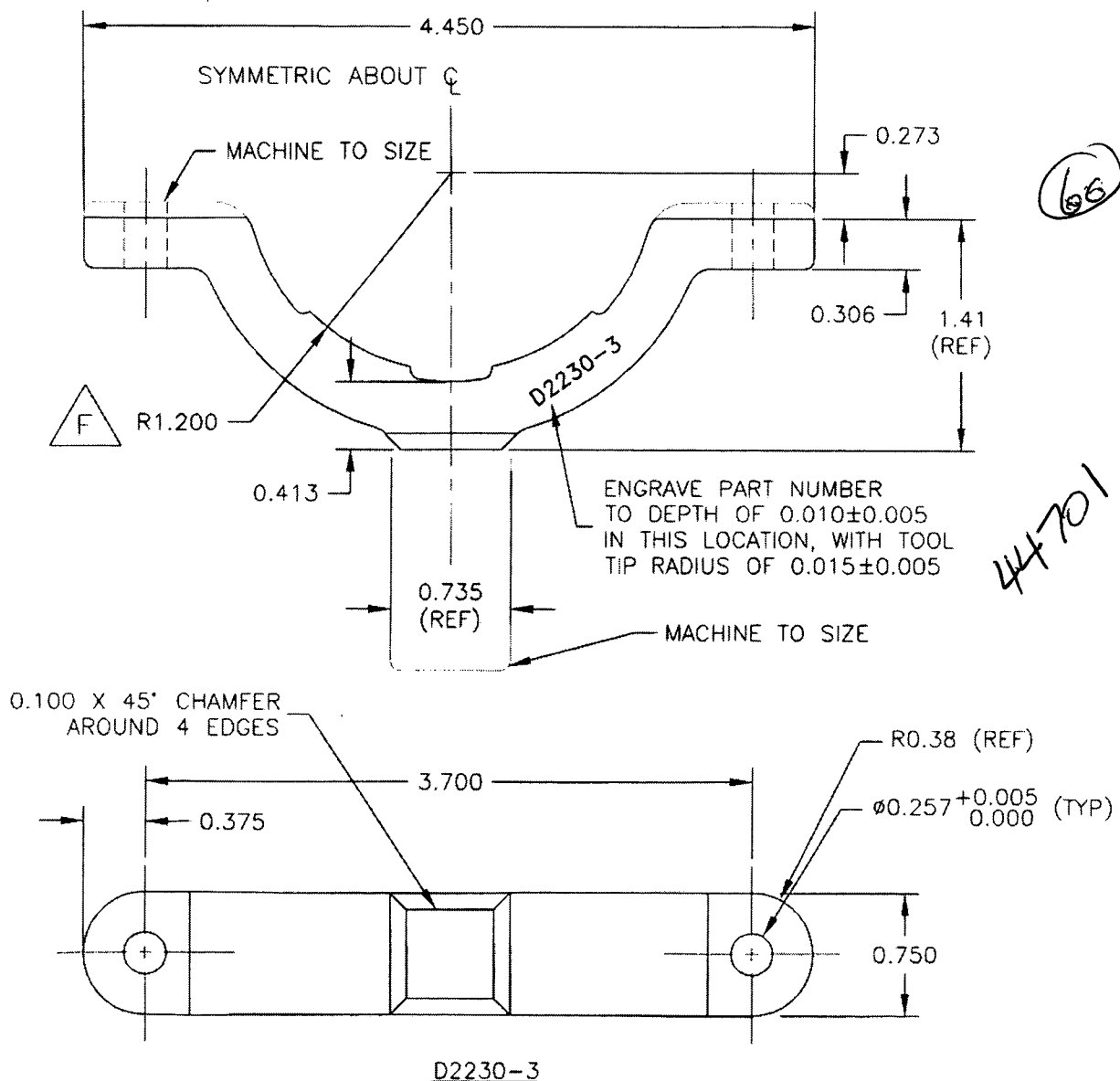
*09/02/05*

*W 09.02.05*



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
[Stamp]



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

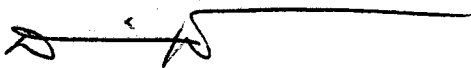
same

<u>Q JANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
202	D2230-1	Mounting Lug	7950
	MATERIAL: supplied by DART D2423 643722		
100	D2230-3	Mounting Lug	7950
	MATERIAL: supplied by DART D2423 643722		

S  
02/01/29

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.



Denise Robinson

Vankleek Hill, January 28, 2009